

**Work Order ID 64820**

Friday, December 17, 2010 8:03:14 AM

Page 1

Item ID: D3639-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-17

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3639

Rev A

100

0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet  
224 .0501-Cut as per Dwg D3639 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Debur if necessary

B11-1-3

8

110

0.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-1-3

120

0.00

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/11/03

X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




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Page 2

Item ID: D3639-1	Accept		Setup	Start	
Revision ID:					
Item Name: Doubler				Stop	
Start Date: 12/16/2010	Start Qty: 6.00		Cust Item ID:		
Required Date: 1/19/2011	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE  Memo Form as per Dwg D3639	0.00  0.00		SB	11/01/04	<u>3</u>			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		Sulor	11/01/04	<u>x6</u>			
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		;)ll	11/01/05	<u>6</u>			

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**Work Order ID 64820**

Friday, December 17, 2010 8:03:14 AM

Page 3

Item ID: D3639-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 BR 11-01-5

170

Identify as per dwg &amp; Stock Location: 244

0.00



Packaging

Memo

0.00

Packaging

C 11/01/06 (8)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C 11/01/06  
C 11/01/06

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 17, 2010 8:03:18 AM

Page 1

Work Order ID: 64820



Parent Item: D3639-1



Parent Item Name: Doubler

Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050		Purchased	No			100	sf	92.3847	0.239	1.509474	2.		
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2024-T3 .050 sheet



B 11-1-3

Location

Loc Qty

Loc Code

MAT22

92.3847

111381

11.89

113189

0.3947

114968

80.1

114968

8

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	64820
<b>Description:</b> Doubler		<b>Part Number:</b>	D3639-1
<b>Inspection Dwg:</b> D3639 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.624	X		V HB02	
Ø0.191	+0.005/-0.001	.190	X		V	
Ø0.098	+0.004/-0.001	.098	X		V	
0.69	+/-0.030	.69	X		V	
1.59	+/-0.030	1.584	X		V	
2.49	+/-0.030	2.490	X		V	
3.39	+/-0.030	3.391	X		V	
3.990	+/-0.010	3.990	X		V	
4.990	+/-0.010	4.991	X		V	
5.19	+/-0.030	5.193	X		V	
6.99	+/-0.030	6.99	X		V	
8.64	+/-0.030	8.649	X		V PROB02	
0.45	+/-0.030	.461	X		V	
0.710	+/-0.010	.710	X		V	
2.000	+/-0.010	1.999	X		V	
2.75	+/-0.030	2.755	X		V	
3.55	+/-0.030	3.554	X		V	
4.00	+/-0.030	4.007	X		V	
2.000	+/-0.010	2.000	X		V	
2.500	+/-0.010				V	

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-1-3	<b>Date:</b> 11/01/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	DS

W/O:		WORK ORDER CHANGES					
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SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

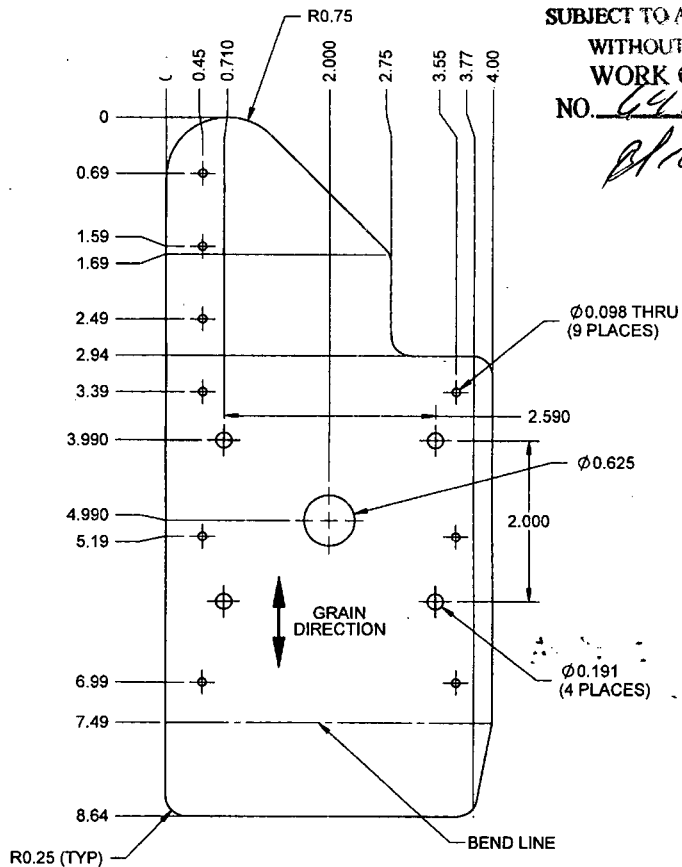
SUBJECT TO AMENDMENT

WITHOUT NOTICE

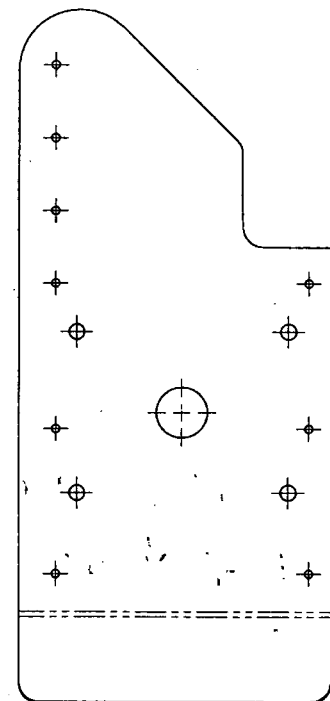
WORK ORDER

NO. 64820

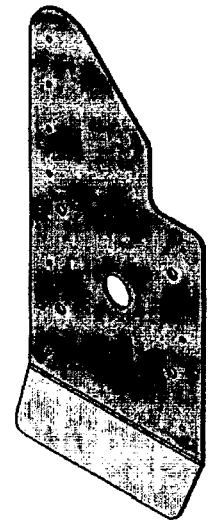
0100-17



**D3639-1F FLAT PATTERN**  
**(D3639-2 OPPOSITE)**



**D3639-1 DOUBLER**  
**(WAS GENEVA P/N G10604-3)**  
**D3639-2 OPPOSITE**  
**(WAS GENEVA P/N G10604-6)**



**RELEASED**  
07-07-07

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART Q31 005 4.1
- 3) TOLERANCES: PER DART Q31 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

A	NEW ISSUE; REPLACES G10604	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	CE		
CHECKED	BE		
MFG. APPR.	BE		
APPROVED	AD		
DE APPR.	AD		
DATE	07.07.27		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D3639			
TITLE DOUBLER			
SHEET 1 OF 2			
SCALE 2:3			
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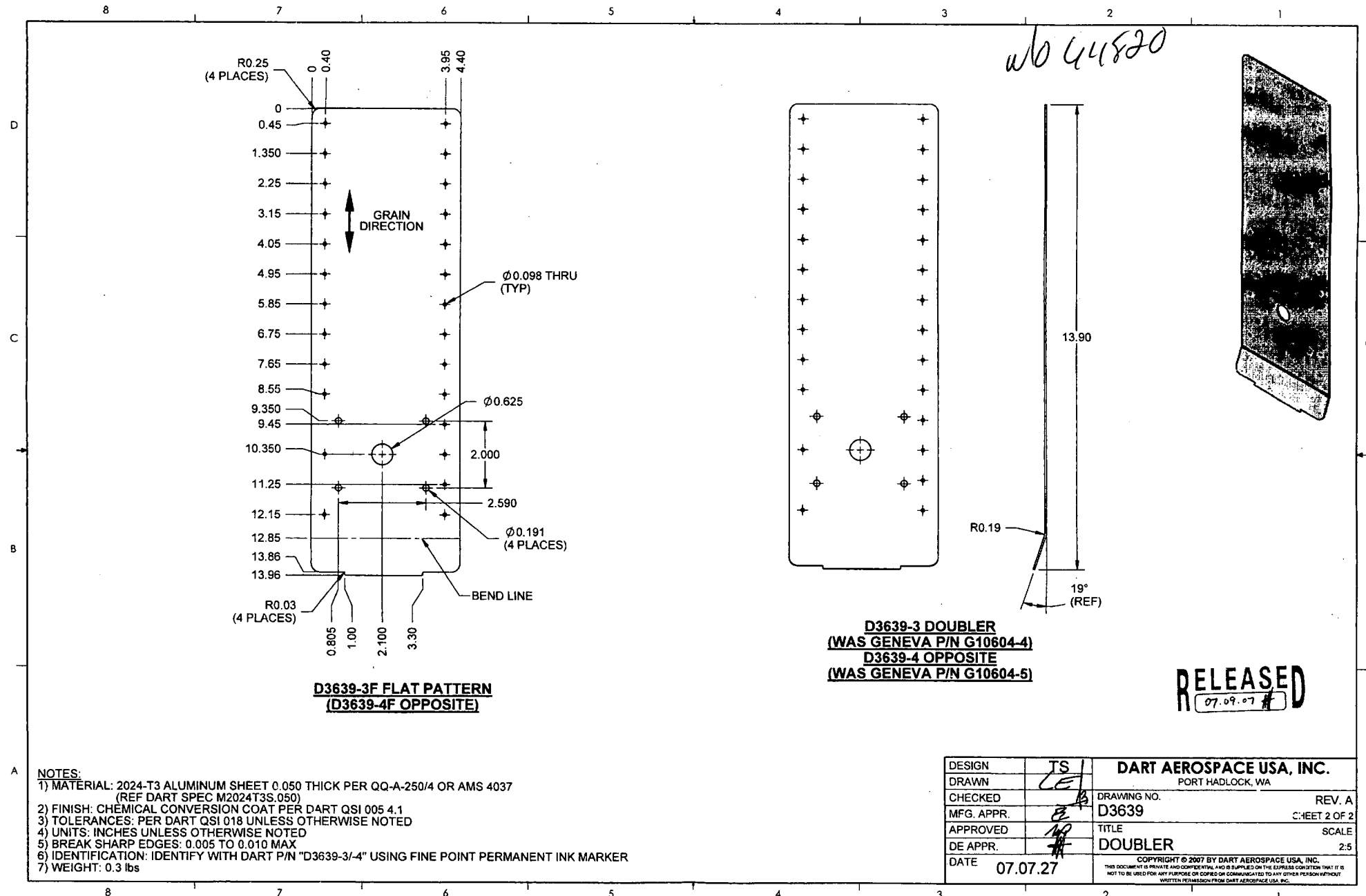
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RELEASE  
07.09.07 #

W/O:		WORK ORDER CHANGES					
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